

5/04

SPLIT

DART AEROSPACE LTD	Work Order:	22032
Description: Fuel Purge Canister	Part Number:	D3262-041
Dwg: D3262 Rev. A	Qty:	1 12
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) D3262-041 consists of (1) D3262-1; (2) D3262-3	HA	04.12.08	12
2	MV	Cut (2) blanks per (1) D3262-041 Cut blanks: 6.000" x 0.500" x 5.400" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B0.500x06.000) Identify for D3262-3 Batch: <u>M11409</u> <u>M11708</u>	En	04/12/15	4
3	MV	Machine as per Folio FA457 and Dwg D3262 Identify as D3262-3	En	04/12/21	4
4	QC2	Inspect parts as they come off the CNC machine	En	04.12.21	4
5	QC8	Second check	En	04.12.21	4
6	MV	Deburr	En	04.12.21	4
7	MV	Cut D3262-1 to length as per Dwg D3262 Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000W.125) Identify as D3262-1 Batch: <u>M15362</u>	En	04/12/21	2
8	WA	Weld canister assembly as per Dwg D3262 using DT8739 to align fillings Pick: Qty Part Number Description Batch A/R Aluminum Rod <u>M15407</u>	PD DD	04-12-21 04/12/21	2
9	QC5	Inspect work to Step 8	HA	04.12.21	2
10	PG	Issue P/O: <u>2007349</u> For Liquid Penetrant inspection as per Dwg D3262, QSI 038 & as per ASTM E1417 Level 1 Possible Supplier: NDT Copy of NDT results is required. <i>Air Pressure test @ 5 PSI submerge in water</i>	U	04.12.21	2
11	RG	Receive and Inspect for transit damage Ensure copy of NDT results are attached.	CL	05/01/10	2
12	QC6	Inspect for damage and ensure results are as per Dwg D3262	U	05/6/13	1
13	FP	Chemical Conversion Coat as per QSI 005 4.1	M	05 07 13	1
14	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 Ensure to mask threads	M	05 07 14	1
15	QC3	Inspect Powder Coat	CL	05/01/17	1
16	ST	Identify with Dart part number and batch number using a fine point permanent ink marker, then Stock	CL	05/01/17	1
17	AC	Cost / part: <u>439.77</u> <u>326.81</u>	SAC	05-01-18	1
18	DC	Close W/O <u>439.77</u> Inspect Level 21	HA	05.01.24	1

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	
B	04.09.29	Added Steps 10-12; changed Step 16	KJ/JLM	

RELEASED
04/01/24

137.16

266.7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22032
Description: Cap		Part Number:	D3262-3
Inspection Dwg: D3262	Rev: A B A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010	0.070x45° ✓			vern	
0.45	+/-0.030	0.456 -			mic	
R0.06	+/-0.030	0.060 -			R.G	
0.080	+/-0.010	0.076 ✓			vern	
0.33	+/-0.030	0.327 ✓			Depth mic	
5.030	+/-0.010					cannot find dim
4.125	+/-0.010					cannot find dim
2.375	+/-0.010					cannot find dim
0.688	+0.005/-0.000	0.688 -			vern	
3.250	+/-0.005	3.248 -			vern	
Ø5.030	+0.010/-0.000	5.030 -			vern	
Ø0.875	+0.005/-0.000	0.875 -			vern	
Ø0.516	+0.005/-0.000	0.516 -			vern	
Ø5.190	+0.005/-0.000	5.190 -			vern	
0.83	+0.015/-0.000	0.83 -			Depth mic	
Ø0.580	+0.015/-0.000	0.580 -			vern	

Measured by: <i>Ep</i>	Audited by: <i>EE</i>	Prototype Approval:	N/A
Date: 04/12/20	Date: 04/12/21	Date:	N/A

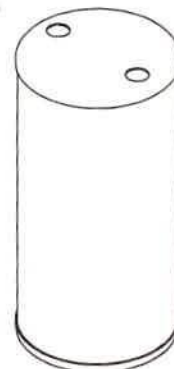
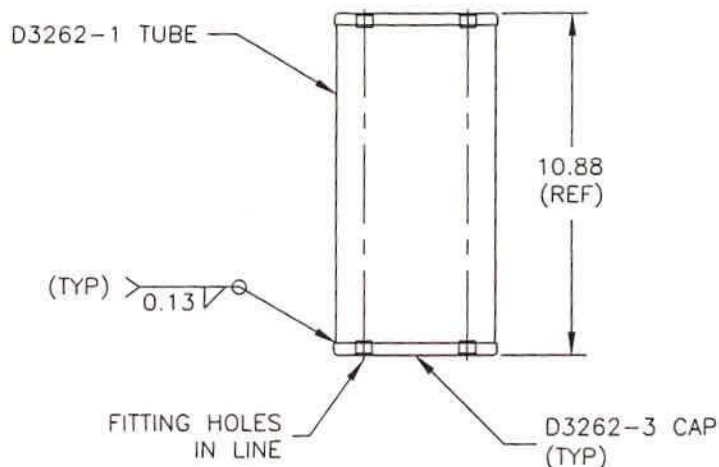
Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue P/O D3262-041	KJ/JLM	<i>[Signature]</i>

RELEASED
04/09/03

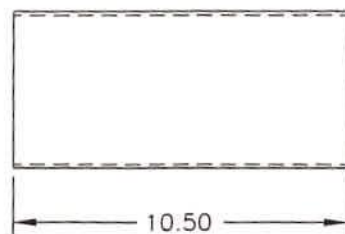


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3262	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	

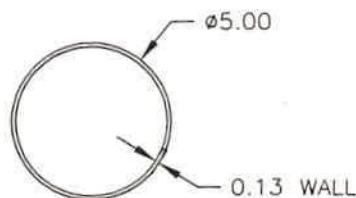
RELEASED
04-07-09 #



D3262-041 CANISTER ASSEMBLY



D3262-1 TUBE



D3262-041:

- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

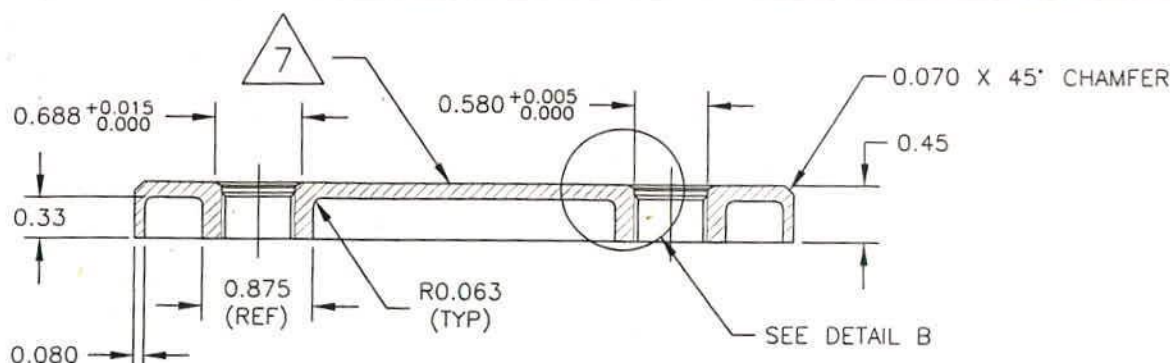
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WORK ORDER
NO. 22032

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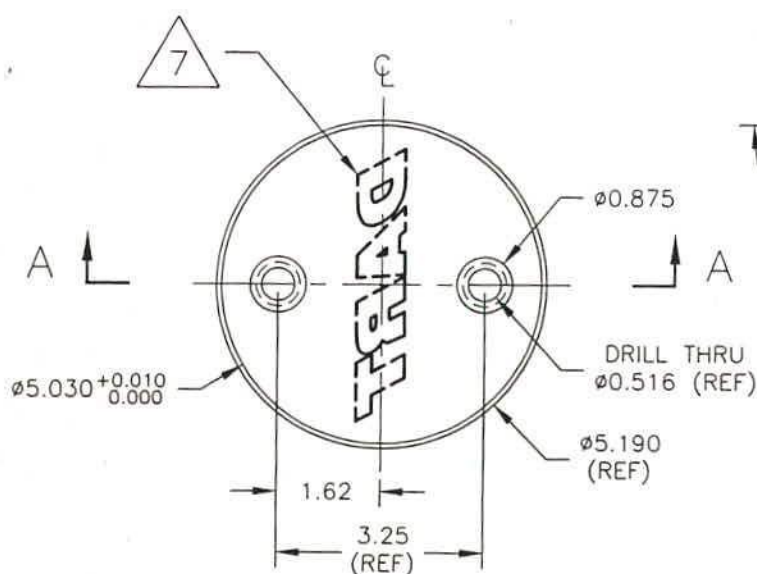
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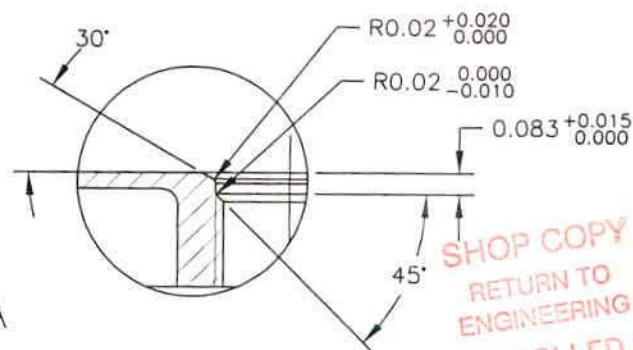
DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RT	APPROVED RT	DRAWING NO. D3262	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE FUEL PURGE CANISTER	SCALE 1:3



SECTION A-A
SCALE 2:3



D3262-3 CAP



DETAIL B
SCALE 4:3

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WORK ORDER
NO. 22032

RELEASED
04.07.04

D3262-3

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No : 0022032
Project Name : D3262-041
Project For : WK504
Work Order Type : Main
Main WO Number :
House Part Number : D3262-041
Description : Fuel Purge Canister
Manufactured : Yes
Amount Req'd : 12
Amount Done : 0
Start Date : 12-03-04
Est Finish Date : 01-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00